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D2597**Job Sheet 187176****Part No:** D2597**Job Qty:** 10 ea**Part Name:** 204 Web**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/28/18**Job Tracking No:****Due Date:** 12/14/18**Created By:** Jesse White**Type:** Stock**Description:**

Note: DWG REV E IPP: D 98.10.15 Eliminated DEO, Changed Dwg Revision KS IPP REV:E ADDED HOLES TO TOOLING 11-09-06 JLM VERIFIED BY:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		12/14/18	0.00	0.00	Start Up Skid tubes		JL
100	Skid tubes	10 pcs		12/14/18	0.00	9.10	Skid tubes		JL
110	QC	10 pcs		12/14/18	0.00	0.00	QC5		BE
120	HandFinish	10 pcs		12/14/18	0.00	4.31	HandFinish1		D.R 18/12/15
130	QC	10 pcs		12/14/18	0.00	0.00	QC7		MBG
140	Packaging	10 pcs		12/14/18	0.00	0.00	Packaging3-1		MBG
150	QC21-SA	10 Ea		12/14/18	0.00	0.00	QC21		

Part Op 100 - Cut D2500-3 to length: 84.25" Use Jig DT9817 to drill pilot holes. Open to 0.625 diameter using a uni-bit.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - Chemical Conversion Coat per QSI005 4.1
 130 - QC7-Inspect Chemical Conversion Coat
 140 - LOCATION : LG002
 150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-3-100	Ext'n - 'I' Beam Web 4"	10 Ea (1 ea)	90-Start up Operation	SCB3738

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-3-100	10	42	0

Part Specifications

Specifications could not be found.

Plex 11/28/18 12:54 PM dart.white.jesse

Entered: _____ Date: _____

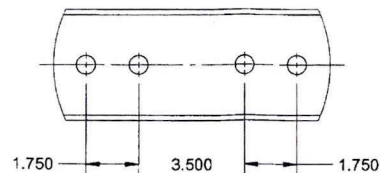


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

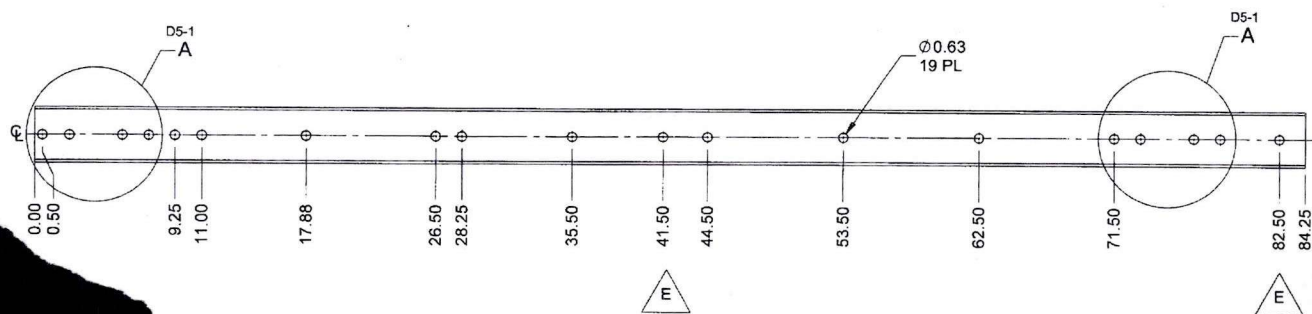
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Description Work Order Deviation DART I AEROSPACE Container No: S134785 Part: D2597 Job No: 187176 Serial No/Batch: S134785 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 12/05/18		QTY Affected: _____ Disposition		MRB (QSI042)	
		Completed By		Lead hand / Supervisor	
		QC / QA Coordinator			
		Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Fatigue ☐ Bending/Twisting ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		FAULT CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
Other/Details:					



DETAIL A C2-1
SCALE 2X C7-1



D2597 WEB (204)

RELEASED
2011-08-29

INTRUSION
SI 005 4.1
SEE NOTED

REV.	DESCRIPTION	BY	DATE
E	ADD HOLES (ZN B5-1, B2-1)	RF	11.06.21
D	INCORPORATED DEO 9097	CP	98.09.14
C	Ø0.63 WAS Ø0.56	KE	97.07.23
B	5.75 WAS 0.50	DS	96.10.29
A	NEW ISSUE	DS	96.09.16
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D2597	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	204 WEB	NTS
DATE	11.06.21	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Incidence #:

QTY Affected :

MRB (QSI042)

Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

☐ Pressure/Forced
☐ Bending
☐ Crushing
☐ Cracks
☐ Crimp/Kink/Ripple/Wave/Twist
☐ Marks/Chatter
☐ Mislabeled

FAULT CATEGORY

☐ Contamination
☐ Misaligned/off center
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Incomplete/Unclear Instructions
☐ Drill Holes
☐ Fit/Function

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain Direction
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set/Set-up

☐ Positioned Wrong
☐ Outside Tolerance
☐ Drawing
☐ Finish
☐ Part Lost/Missing
☐ Misread

Other/Details: